

Work Order ID 160725

Wednesday, May 03, 2017 11:04:40 AM

160725

Page 1

Ship May 30

Item ID: K10111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Skidtube 206
 Start Date: 5/10/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/17/2017 Req'd Qty: 4.00 *4* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: DAS 21 Date: MAY 03 2017 Tooling: Date: Run Start *NR1*
 QC: 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10111	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG009 FOR D206-642-113 CHG005	K10111 CHG003							
110	Pick Kit	0.00							
110	Memo	0.00							
Packaging									
Packaging									

MAY 24 2017

DAS 6 9-89

2

DAS 28 9-89

JUN 13 2017

2

DAS 6 9-89

DAS 27 9-89

MAY 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Skidtube 206
Start Date: 5/10/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.12				2 DAS 28 9-89		JUN 13 2017	
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: 1X PPP160723 PPP rev: 1X PPP160724	0.00 0.00				2 DAS 28 9-89		JUN 13 2017	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40				DAS 21 9-89		JUN 14 2017	

DAS
21
9-89

JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

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Page 1

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	90.0000	8	32 16		MAY 26 2017	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20					
				122416				20					
				ST347				70					
				123355				28					
				m137321				42					
AN4-6A *AN4-6A* BOLT		Purchased	No			110	Each	572.0000	12	48 24		MAY 26 2017	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over003				400					
				M137320				400					
				ST345				172					
				M136851				10					
				M137178				162					
AN4C5A *AN4C5A* Bolt		Purchased	No			110	Each	70.0000	1	42 24		MAY 26 2017	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				38					
				m133990				38					
				ST345				32					
				m137164				32					

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
								OTHER :	

Picklist Print

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Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

AN5-10A Purchased No

110 Each 137.0000 4 16.8

AN5-10A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

29

122800

29

ST338

108

m137321

108

110 Each 69.0000 4 16.8

AN5-11A Purchased No

AN5-11A

BOLT

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338

69

M136648

8

M137361

61

110 Each 166.0000 2 8.4

AN6-44A Purchased No

AN6-44A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

over008

150

123265

150

ST333

16

123265

16

MAY 26 2017

DAS 6 27
9-89 9-89

MAY 26 2017

DAS 6 27
9-89 9-89

MAY 26 2017

DAS 6 27
9-89 9-89

Picklist Print

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Page 3

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

D206-651-041

Manufactured No

110

Each

6.0000

1

42

D206-651-041

206 A/B Ground Handling Wheel

**

MAY 26 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

1

79558

1

ST365

5

146661

4

155643

1

2

D2652

Manufactured No

110

Each

44.0000

16

64 32

D2652

Bushing

**

MAY 26 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

44

31985

44

D2661-1

Manufactured No

110

Each

2.0000

2

160401
84

D2661-1

Saddle, LH, Fwd, Aft, Out

**

MAY 26 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

80989

2

D2662-1

Manufactured No

110

Each

5.0000

2

160726
84

D2662-1

Saddle, LH Fwd, Aft, In

**

MAY 26 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

80991

2

ST401

3

124309

1

149491

2

161621X1

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

D2712 Manufactured No

110 Each

272.0000

10

D2712

Set Screw

**

DAS
6
9-89

DAS
27
9-89

MAY 26 2017

Location

Loc Qty

Loc Code

FG 50

29962 50

ST010 22

159501 12

89929 10

ST012a 200

153570 200

DAS
28
9-89

D2884 Manufactured No

110 Each

12.0000

2

D2884

Saddle Spacer

**

DAS
6
9-89

DAS
27
9-89

MAY 30 2017

Location

Loc Qty

Loc Code

FG 10

29453 10

ST013 2

135977 2

DAS
28
9-89

D2885 Manufactured No

110 Each

22.0000

2

D2885

Saddle Spacer

**

DAS
6
9-89

DAS
27
9-89

MAY 26 2017

Location

Loc Qty

Loc Code

FG 10

29199 10

ST013 12

144567 12

DAS
28
9-89

Picklist Print

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Page 5

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

32.0000

1

42

D3413-1

O-Ring

**

DAS
6
9-89

DAS
27
9-89
MAY 26 2017

Location

Loc Qty

Loc Code

FP001

2

145648

2

st530

30

145648

1

151731

4

153479

12

155256

12

159722

1

2

DAS
28
9-89

MS21042L3

Purchased

No

110

Each

1,534.000

8

32 16

MS21042L3

Nut

**

DAS
6
9-89

DAS
27
9-89
MAY 26 2017

Location

Loc Qty

Loc Code

FP001

91

m135945

91

GA

464

m134360

102

M136665

362

ST303

979

m137073

11

m137166

3

m137321

965

16

DAS
28
9-89

Picklist Print

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Page 6

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

3,142.000

12

48-24

MS21042L4

Nut

**

DAS
6
9-89

MAY 26 2017
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

148

m135058

148

OVER007

1400

m137371

1000

m137402

400

ST303

1584

m136986

3

m137166

12

m137321

1569

24

MS21042L6

Purchased

No

110

Each

205.0000

2

8-4

MS21042L6

Nut

**

DAS
6
9-89

MAY 26 2017
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER007

100

m137361

100

ST303

50

m137075

50

ST313

55

m136740

5

m136986

50

4

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Shop Packet Print

Page 6

Picklist Print

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Page 7

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0463R

Purchased

No

110

Each

234.0000

1

4 2

DAS
6
9-89

NAS1149C0463R

Washer

**

DAS
27
9-89

MAY 26 2017

Location

Loc Qty

Loc Code

FP001

25

m127306

25

ST266

209

m134167

9

m136263

200

110

Each

689.0000

8

32 16

DAS
6
9-89

NAS1149D0363J

Purchased

No

NAS1149D0363J

Washer

**

DAS
27
9-89

MAY 26 2017

Location

Loc Qty

Loc Code

GA

42

m134055

42

ST263

647

m137061

100

m137164

547

110

Each

4,372.000

24

96 48

DAS
6
9-89

NAS1149D0463J

Purchased

No

NAS1149D0463J

Washer

**

DAS
27
9-89

MAY 26 2017

Location

Loc Qty

Loc Code

GA

48

M135056

48

ST260a

4000

M137371

2000

M137381

2000

ST263

324

M137166

324

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Page 8

Work Order ID: 160725

160725

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

971.0000

8

32 16

NAS1149D0563.J

Washer

**

DAS

DAS

6

27

9-89

9-89

MAY 2 6 2017

Location

Loc Qty

Loc Code

GA

110

m135774

110

ST263

861

m136295

7

m136986

54

m137361

800

16

NAS1149D0663J

Purchased

No

110

Each

965.0000

4

16 8

NAS1149D0663.J

Washer

**

MAY 2 6 2017

Location

Loc Qty

Loc Code

ST260a

600

M137361

600

ST263

365

M136787

365

8

DAS
28
9-89

DAS
28
9-89

DAS
27
6 9-89
9-89

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
	X		D206-642-113	SKIDTUBE INSTALLATION, LH
		X	D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 160797
 4-05-03

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	160	TITLE	SCALE
DE APPR.	160	BOLT SUBSTITUTION	NTS
DATE	11.11.02		
COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
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REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 160725

Wednesday, May 03, 2017 11:04:40 AM

160725

Page 1

Item ID: K10111

Revision ID:

Item Name: Saddle, Skidtube 206

Start Date: 5/10/2017 Start Qty: 4.00

Required Date: 5/17/2017 Req'd Qty: 4.00

Reference: SCHEDULED/C

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: MAY 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
DSI 9583	A
K10111	C

MAY 26 2017

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP K10111 CHG003
FOR D206-642-111 CHG009
FOR D206-642-113 CHG005

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging